

Date: Wednesday, 02/04/2008 11:27:20 AM  
 User: Julie Lecocq

## Process Sheet

|                                  |                                                               |                 |                     |                         |                         |                 |
|----------------------------------|---------------------------------------------------------------|-----------------|---------------------|-------------------------|-------------------------|-----------------|
| <b>Customer</b>                  | : CU-DAR001 Dart Helicopters Services                         |                 | <b>Drawing Name</b> | : 205 SKIDTUBE "I" BEAM |                         |                 |
| <b>Job Number</b>                | : 38294                                                       |                 |                     |                         |                         |                 |
| <b>Estimate Number</b>           | : 10346                                                       |                 |                     |                         |                         |                 |
| <b>P.O. Number</b>               | :                                                             |                 |                     |                         | <b>Part Number</b>      | : D2596         |
| <b>This Issue</b>                | : 02/04/2008                                                  | <b>S.O. No.</b> | :                   |                         | <b>Drawing Number</b>   | : D2596 REV D   |
| <b>Prsht Rev.</b>                | : NC                                                          |                 |                     |                         | <b>Project Number</b>   | : N/A           |
| <b>First Issue</b>               | : / /                                                         | <b>Type</b>     | : LANDING GEAR      |                         | <b>Drawing Revision</b> | : D             |
| <b>Previous Run</b>              | : 37753                                                       |                 |                     |                         | <b>Material</b>         | :               |
| <b>Written By</b>                | :                                                             |                 |                     |                         | <b>Due Date</b>         | : 09/04/2008    |
| <b>Checked &amp; Approved By</b> | : <u>JD 08.04.02</u>                                          |                 |                     | <b>Qty:</b>             | 4                       | <b>Um:</b> Each |
| <b>Comment</b>                   | : Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D M |                 |                     |                         |                         |                 |
|                                  | Est Rev:E 07-07-09 Incorporated DEO 9183 JLM                  |                 |                     |                         |                         |                 |

## Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description :                                                                                                                                                                            |                 |
|---------|-----------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------|
| 1.0     | D25003100             | Ex'tn - I' Beam Web 4"                                                                                                                                                                   |                 |
|         |                       |                                                                                                                                                                                          |                 |
|         |                       | <b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)<br>Extrusion "I" Beam Web 4"<br>Pick;<br>Qty Part Number Description Batch                                              |                 |
|         | 1 D2500-3-100         | Extrusion                                                                                                                                                                                | <u>B 33940</u>  |
| 2.0     | SKIDTUBES 1           | SKIDTUBESS RESOURCE 1                                                                                                                                                                    |                 |
|         |                       |                                                                                                                                                                                          |                 |
|         |                       | <b>Comment:</b> LANDING GEAR RESOURCE 1<br>1- Cut D2500-3-100 to length: 99.5"<br>2- Use Jig DT8093 to drill pilot holes #30<br>3- Open to 0.630" diameter as per Dwg D2596<br>4- Deburr | <u>JD 8-4-9</u> |
| 3.0     | HAND FINISHING1       | HAND FINISHING RESOURCE #1                                                                                                                                                               |                 |
|         |                       |                                                                                                                                                                                          |                 |
|         |                       | <b>Comment:</b> HAND FINISHING RESOURCE #1<br>Acid Etch and Alodine per QSI 005 4.1                                                                                                      | <u>JD 8-4-9</u> |
| 4.0     | QC5                   | INSPECT WORK TO CURRENT STEP                                                                                                                                                             |                 |
|         |                       |                                                                                                                                                                                          |                 |
|         |                       | <b>Comment:</b> INSPECT WORK TO CURRENT STEP                                                                                                                                             | <u>8-4-11</u>   |
|         |                       |                                                                                                                                                                                          |                 |

| W/O: |      | WORK ORDER CHANGES |  |  |    |      |     |                                     |                          |
|------|------|--------------------|--|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |  |  |    |      |     |                                     |                          |
|      |      |                    |  |  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                  |                                 |                |                           |                       |                          |
|------|------|----------------------------------|----------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action      Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng             | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                  |                                 |                |                           |                       |                          |
|      |      |                                  |                                  |                                 |                |                           |                       |                          |
|      |      |                                  |                                  |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 SKIDTUBE "I" BEAM

Job Number: 38294

Part Number: D2596

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Skid tube cell

ST 08-04-12 X4

6.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/15 J

Job Completion



MF 08-04-15

Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

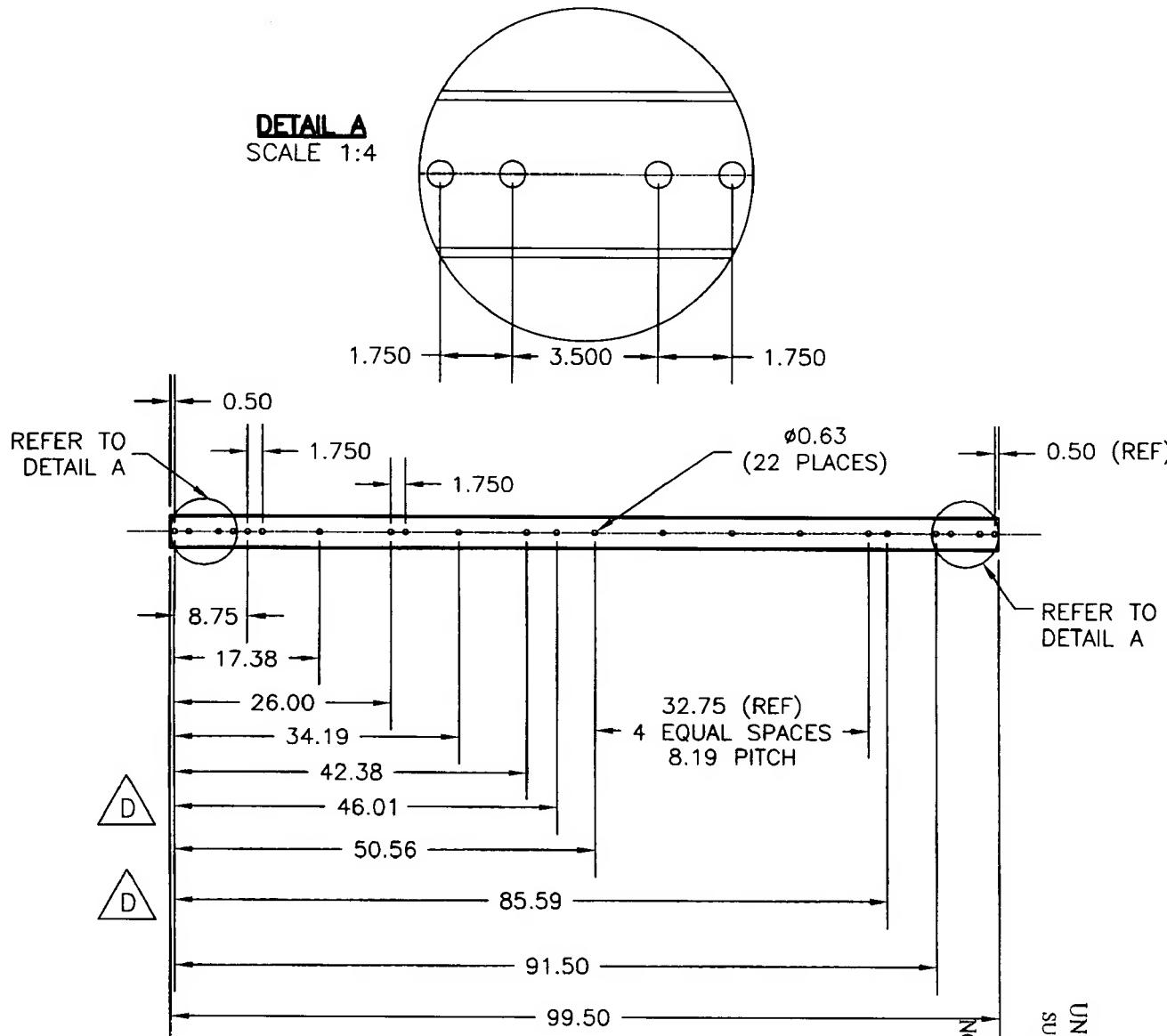
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

**DART****RELEASED**

07.04.17

|                             |                                              |                                                                                     |                        |
|-----------------------------|----------------------------------------------|-------------------------------------------------------------------------------------|------------------------|
| DESIGN<br><i>P4</i>         | DRAWN BY<br><i>P4</i>                        | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                            |                        |
| CHECKED<br><i>[initial]</i> | APPROVED<br><i>[initial]</i>                 | DRAWING NO.<br>D2596                                                                | REV. D<br>SHEET 1 OF 1 |
| DATE<br>07.04.17            | TITLE<br>205 WEB                             | SCALE<br>1:20                                                                       |                        |
| A<br>B<br>C<br>D            | 96.09.16<br>97.07.23<br>98.09.14<br>07.04.17 | NEW ISSUE<br>φ0.63 HOLE WAS φ0.56<br>INCORPORATED DEO 9097<br>INCORPORATED DEO 9183 |                        |

**D2596 WEB**

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020